

Date: Monday, 5/14/2007 2:00:54 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 32345		
Estimate Number	: 12806		
P.O. Number	:	Part Number	: D35702
This Issue	: 5/14/2007	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3570 REV.B
First Issue	: / /	Project Number	: N/A
Previous Run	: 31867	Drawing Revision	: B
	Type : SMALL / MED FAB	Material	:
Written By	:	Due Date	: 5/15/2007
Checked & Approved By	:	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 07-03.26 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
<p>Comment: Qty.: 0.0746 sf(s)/Unit Total: 1.4910 sf(s) 6061-T6 .125 Sheet Batch: <u>M103156</u> ***Grain must be Along 4.63*****</p> <p>SAD 07/05/14</p>		
2.0	WATER JET	FLOW WATER JET
<p>Comment: FLOW WATER JET 1-Cut as per Dwg D3570 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary</p> <p>SAD MF 07/05/14 07-05-22</p> <p>20 PTO</p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p>SAD 07/05/14</p> <p>20</p>		
4.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK</p> <p>07-05-22</p> <p>20</p>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1</p> <p>Form as per Dwg D3570</p> <p>07-08-03 20</p> <p>PTO</p>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3570-2 PAR #: N/A Fault Category: PROD-SM-FAB NCR: Yes No DQA: JA Date: 07.08.13
QA: N/C Closed: JA Date: 07.08.21

NCR: <u>32345</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/14	2.0	Scrap 3 part had to change offset and speed in program.	<u>ASIAH</u>	Scrap-destroy, replace B# <u>M103156</u>	SAD 07/05/14	<u>ASIAH</u>	<u>ASIAH</u>	0705-15
07/05/14	2.0	Scrap 2 part program malfunction	<u>ASIAH</u>	Scrap-destroy, replace B# <u>M103156</u>	SAD 07/05/14	<u>ASIAH</u>	<u>ASIAH</u>	0705-15
07/08/07	5.0	apare inspection found 7 parts with 0.365 under tol. Dim varying from 0.352 to 0.328" RL Human Error. Part were	<u>JA</u>	ACCEPTABLE DEVIATION	<u>JA</u> 07.08-07	<u>JA</u> 07/08/07	<u>JA</u> 07.08-07	En 07/08/07

NOTE: Date & initial all entries must be and cat shot.

Date: Monday, 5/14/2007 2:00:55 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32345

Part Number: D35702

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ep 07/08/07 (19) count

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 07 08 10

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M104846

ml 07/08/11

(19) KIX

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ep 07/08/13 (19)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock Location: _____

Ep 07/08/13 (19)

11.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

07.08.13

Job Completion



C 207/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

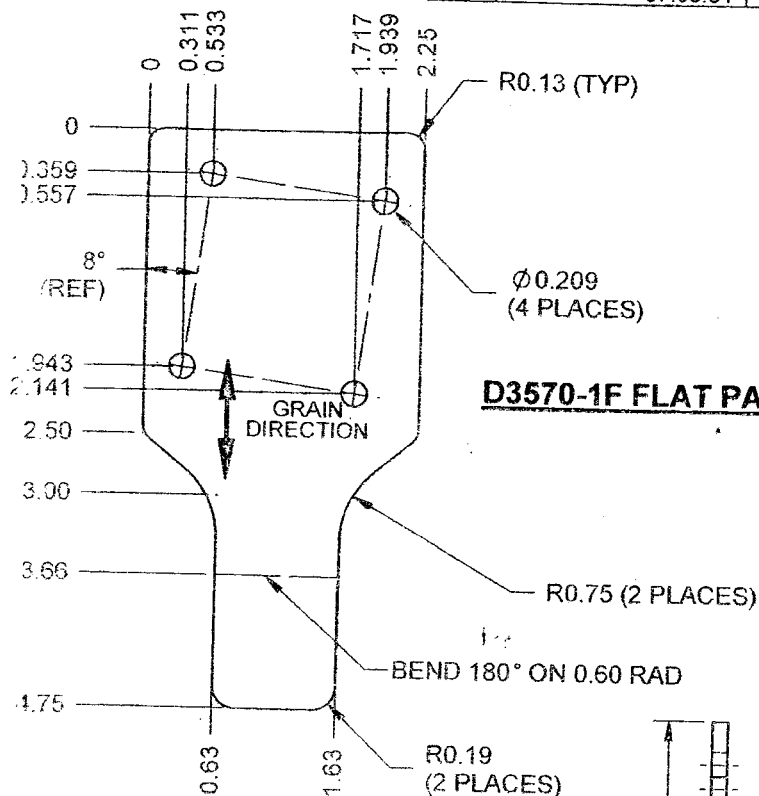
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>A</i>	DRAWING NO. D3570	REV. C SHEET 1 OF 1
DATE 07.06.01		TITLE BRACKET	SCALE 2:3
REV	DATE	DESCRIPTION	
A	07.02.07	NEW ISSUE	
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50	
C	07.06.01	UPDATE DIMS FOR CLARITY	



D3570-1F FLAT PATTERN

RELEASED

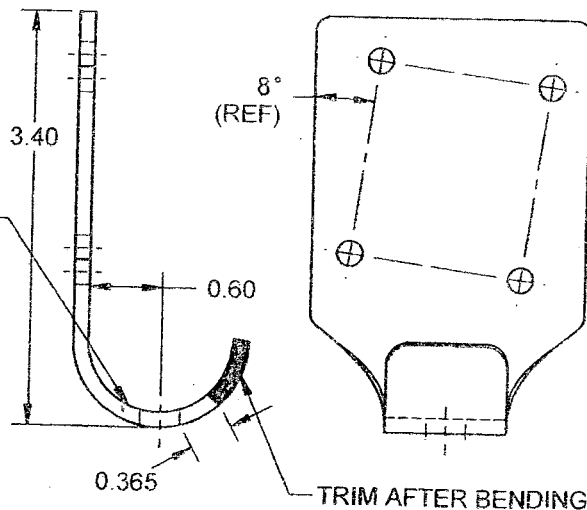
07.06.01 *A*

w/c 32314

DRILL Ø0.328 AFTER BENDING
CENTERED ON PART & ON BEND

D3570-1 BRACKET SHOWN
(MAKE FROM D3570-1F)

D3570-2 BRACKET OPPOSITE
(MAKE FROM D3570-1F)



NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 32 345
Description: Beampaw BRACKET		Part Number: D35702
Inspection Dwg: D35702 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.359	± 0.010	0.364	✓		Vern	
B	0.557	± 0.010	0.561	✓		Vern	
C	0.943	± 0.010	1.943	✓		Vern	
D	2.141	± 0.010	2.143	✓		Vern	
E	2.50	± 0.030	2.51	✓		height gauge	
F	4.75	± 0.030	4.76	✓		Vern	
G	0.63	± 0.030	0.64	✓		height gauge	
H	1.63	± 0.030	1.65	✓		height gauge	
I	0.311	± 0.010	0.316	✓		Vern	
J	0.533	± 0.010	0.536	✓		Vern	
K	1.717	± 0.010	1.720	✓		Vern	
L	1.939	± 0.010	1.944	✓		Vern	
M	2.25	± 0.030	2.26	✓		Vern	
N	0.209	± 0.005	0.209	✓		Vern	
O	0.125	± 0.010	0.120	✓		Vern	
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: BAD	Audited by: <i>BE</i>	Prototype Approval: <i>LE</i>
Date: 07/05/14	Date: 07-05-14	Date: NA 07-05-14

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	